

Date: Tuesday, 1/23/2007 7:33:34 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOCK PLATE
Job Number	: 30398		
Estimate Number	: 10332		
P.O. Number	: N/A	Part Number	: D2534
This Issue	: 1/23/2007 S.O. No. : N/A	Drawing Number	: D2534 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 27691A	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 1/29/2007
Checked & Approved By	: <u>107.01.23</u>	Qty:	50 Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-06-20 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0448 sf(s)/Unit Total : 2.2418 sf(s)  
 304/316 .125 Sheet  
 (M304S11GA)  
 Batch: m102817 ml 07 01 31 (50)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2734  
 Dwg Rev: D ml 07 01 31 (50)  
 Prog Rev: D  
 2-Deburr if necessary SAN 02/02/12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

107/01/05 (50)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: welding

107/02/12 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1/3 Date: 07/02/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/23/2007 7:33:34 AM  
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Drawing Name: LOCK PLATE

Job Number: 30398

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



58

Comment: FINAL INSPECTION/W/O RELEASE

07/02/13

Job Completion



u 07.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

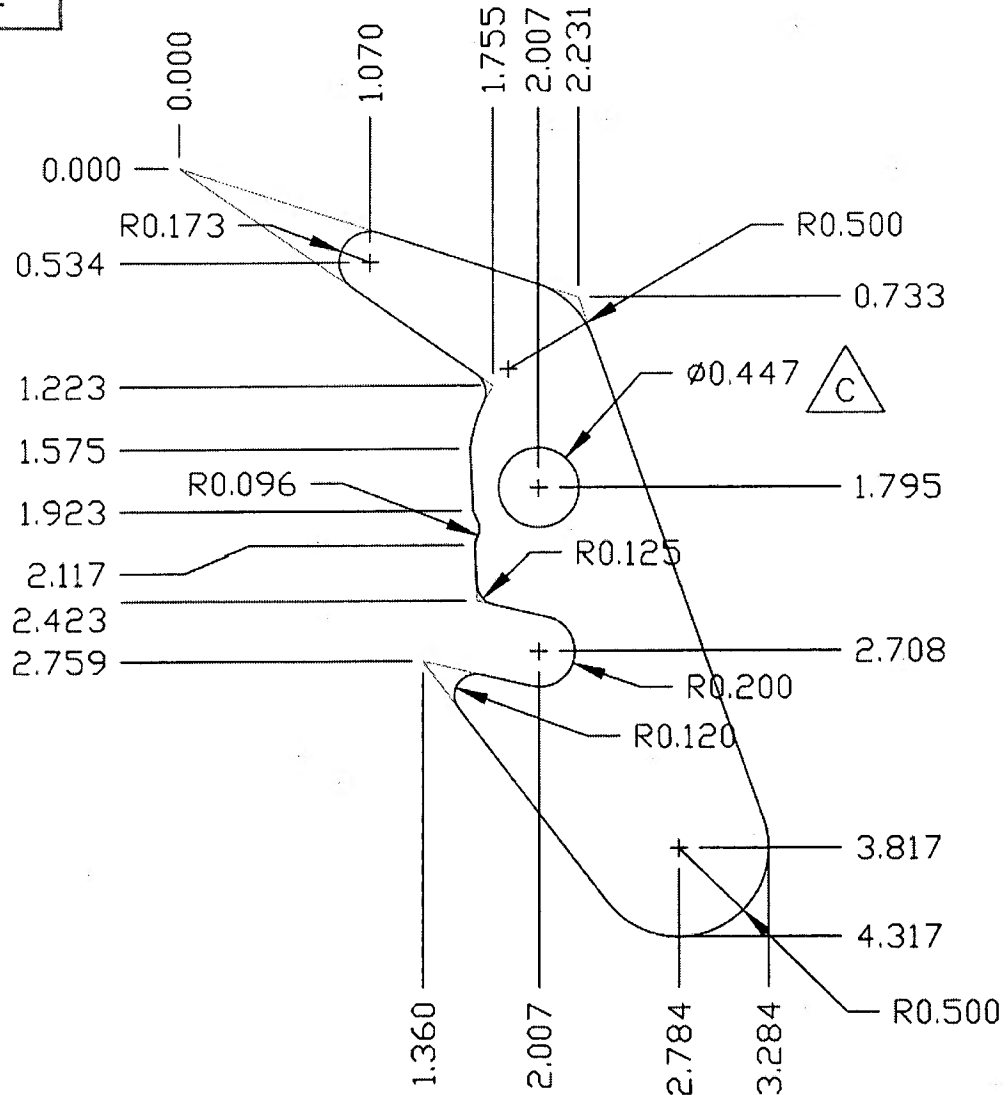
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>[Signature]</i>	<i>[Signature]</i>	D2534	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	LOCK PLATE		1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

**RELEASED**04.12.16 *[Signature]***D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30398

DART AEROSPACE LTD		Work Order: 30398
Description: Lock plate		Part Number: D2534
Inspection Dwg: D2534 Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.447	+0.006 - 0.001	0.447	✓		vern	
RD.173	H-0.010	RD.173	✓		RADIUS GAUGE	
RD.500	+/-0.010	RD.500	✓		RADIUS GAUGE	
RO.096	+/-0.010	RO.096	✓		RADIUS GAUGE	
RO.125	+/-0.010	RO.125	✓		RADIUS GAUGE	
RO.200	+/-0.010	RO.200	✓		RADIUS GAUGE	
RO.120	+/-0.010	RO.120	✓		RADIUS GAUGE	
RO.500	+/-0.010	RO.500	✓		RADIUS GAUGE	

Measured by: M.M	Audited by: DA	Prototype Approval:
Date: 07/01/31	Date: 07/02/05	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	